



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4021-9
Job Sheet 167147



Part No: D4021-9

Job Qty: 100 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/25/17

Job Tracking No:

Due Date: 11/3/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	100 Ea		11/2/17	0.00	0.00	Start Up Machining	
100	Hardinge	100 pcs		11/3/17	0.00	5.43	Hardinge	
120	QC	100 pcs		11/3/17	0.00	0.00	QC8	
130	Packaging	100 pcs		11/3/17	0.00	0.00	Packaging3	
140	QC21-SA	100 Ea		11/3/17	0.00	0.00	QC21	
Part Op 100 - TURN AS PER FOLIO FA 868 AND DWG D4021 DWG REV: _____ FOLIO REV: _____								
Descriptions: ***MACHINE TO .375" MAX OD ***								
130 - LOCATION: WA004								

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304R0.375	8	33	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.191Inches + 0.005 - 0.001	0.196 0.190	Diameter	
2	Bushing	0.380Inches ± 0.030	0.410 0.350		
3	Bushing	0.750Inches ± 0.030	0.780 0.720		

Plex 10/25/17 8:58 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval

Descr

DART
AEROSPACE

S002071



Bushing

Dart Aerospace Ltd.

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CANADA
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Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

PART NO: D4021-9

Revision:

Operation:

Quantity:

Change No:

Start up Operation
100

Mfg Date: 10/25/17

Job No: 167147

Root Cause							
Environment	☐	Nc	☐	er Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Op	☐	i/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Of	☐	n	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Su	☐	d	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	ng Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐				
OTHER :							

